

Date: Friday, 30/05/2008 10:56:24 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT FACING SEAT ASSY LH FOR ENGINEERING USE ONLY		
Job Number	: 39609		Part Number	: D412769041		
Estimate Number	: 13306		Drawing Number	: D412-769-041 PROTO		
P.O. Number	:		Project Number	: N/A		
This Issue	: 30/05/2008		Drawing Revision	: PROTO		
Prsht Rev.	: NC		Material	:		
First Issue	: 30/05/2008		Due Date	: 06/06/2008		
Previous Run	:		Qty:	1	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est rev A 08.05.12 new issue DD verified by:					

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D3782045	Back Leg Assembly	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Back Leg Assembly batch: B39649	 080603
3.0	D3782041	Front Inboard Leg Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Inboard Leg Assembly batch: B05014	 080603
4.0	D3782043	Front Outboard Leg Assembly, LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Outboard Leg Assembly, LH batch: B05013	 080603
5.0	D3783041	Lateral Brace Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lateral Brace Assembly batch: B05005	 080603

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Part Number: D412769041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D3783043 Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly
batch: B305006

80

080603

7.0 D3783045 Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly
batch: B305007

80

080603

8.0 D3784041 Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center
batch: B305010

80

080603

9.0 D3784043 Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH
batch: B305009

80

080603

10.0 D3784044 Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH
batch: B305008

80

080603

11.0 D37661 Front Rail, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail
batch: B38868

80

080603

12.0 D37663 Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail
batch: B388679

80

080603

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Part Number: D412769041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37671 Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B38866

ST

080603

14.0 D37921 Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: _____

use BHT P/N 205-070-725-011

ST

080603

15.0 AN45 13A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M107938

ST

080603

16.0 AN515A Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

batch: M108077

ST

080603

17.0 AN510A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M107013

ST

080603

18.0 AN513A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M107321

ST

080603

19.0 NAS1149F0563P Washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Washer

batch: M108099

ST

080603

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Part Number: D412769041

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 NAS1149F0463P Washer



AN960-416



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M5519

JK

080603

21.0 MS21042L5 Nut



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Nut

batch: M107464

JK

080603

22.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M107478

JK

080603

23.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M107737

JK

080603

24.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-041

JK

080604

25.0 QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP

26.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1-mask D3787-1 foot and around area of red powder coat as per dwg D412-769-041

2-Powder coat only D3782-041 and D3782-043 front legs in red as per dwg D412-769-041

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

1. *Q. R. K. A. F. S. P. C. S.*
2. *Q. R. K. A. F. S. P. C. S.*
3. *Q. R. K. A. F. S. P. C. S.*

Date: Friday, 30/05/2008 10:56:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY LH

Job Number: 39609

Part Number: D412769041

Job Number:



Seq. #: Machine Or Operation:

Description :

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

27.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

28.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-041

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

29.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

30.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37741 Seat Bottom, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: _____

32.0 D37743 Seat Back, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Back, LH

batch: _____

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Job Number: 39609

Part Number: D412769041

Job Number:



Seq. #: Machine Or Operation:

Description :

33.0 AN52510R24

Screw



ANS2510R22



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

batch: M107936

ST 080604

34.0 NAS1149F0363P

Washer



AN960-10



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Washer

batch: M15519

ST 080604

35.0 MS21042L3

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

batch: M107644

ST 080604

36.0 AN35A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100188

ST 080604

37.0 D412724041

Head Rest Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, Center

batch: B38956

ST 080604

38.0 D412724043

Head Rest Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Head Rest Assembly, LH

batch: B38957

ST 080604

39.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-041

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Job Number: 39609 Part Number: D412769041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**

41.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

42.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

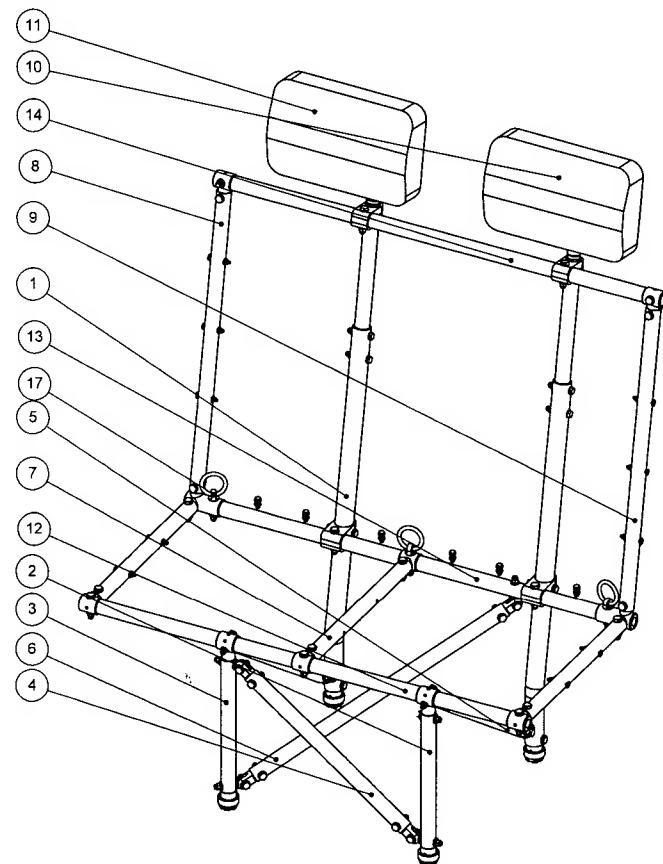
Job Completion



charge to W10#0096
U 28.06.11

8 7 6 5 4 3 2 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D412-724-041	HEAD REST ASSY, CENTER	1
11	D412-724-043	HEAD REST ASSY, LH	1
12	D3766-1	FRONT RAIL, LH	1
13	D3766-3	REAR RAIL	1
14	D3767-1	UPPER RAIL	1
15	D3774-1	SEAT BOTTOM, LH	1
16	D3774-3	SEAT BACK, LH	1
17	D3792-1	SEAT BELT EYE BOLT	3
18	AN45-13A	EYE BOLT	1
19	AN5-10A	BOLT	6
20	AN5-13A	BOLT	2
21	AN5-15A	BOLT	9
22	AN4-15A	BOLT	2
23	AN3-5A	BOLT	6
24	AN525-10R24	SCREW	10
25	MS21042L3	NUT	16
26	MS21042L4	NUT	2
27	MS21042L5	NUT	21
28	NAS1149F0363P	WASHER	22
29	NAS1149F0463P	WASHER	4
30	NAS1149F0563P	WASHER	38



QTY X1 D412-769-041 AFT FACING SEAT ASSY, LH

A	NEW ISSUE	HS	08.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D412-769-041	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
DATE	08.05.28	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR THAT IT IS NOT COPIED OR COMMUNICATED TO OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDTEX" (4,3,5,6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/3) AND HEADRESTS (D412-724-041/-043). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK OF SEAT BACK
- 7) WEIGHT: 42.67 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM, LH) AND ITEM 16 (D3774-3 SEAT BACK, LH) REMOVED FOR CLARITY

8 7 6 5 4 3 2 1

